

Ship date 17/9/26

Work Order ID 166432

166432

Page 1

Thursday, September 21, 2017 4:33:27 PM

Item ID: D350-567-145 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Window Close Out (AS350 B3e)
 Start Date: 9/21/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/3/2017 Req'd Qty: 1.00 *1* Customer:
 Reference: 5132468

Approvals: Process Plan: WY Date: 17/9/21 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-145 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

SEP 22 2017

DAS
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9-89

SEP 22 2017

DAS
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DAS
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SEP 22 2017

DAS
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SEP 22 2017

Work Order ID 166432

Thursday, September 21, 2017 4:33:27 PM

166432

Page 2

Item ID: D350-567-145**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Floor Window Close Out (AS350 B3e)**Start Date:** 9/21/2017 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 10/3/2017 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging								
	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-145 Location: FG033								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
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SEP 22 2017

17/9/25

SEP 22 2017

Picklist Print

Thursday, September 21, 2017 4:33:26 PM

Page 1
6

Work Order ID: 166432

166432

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 9/21/2017

Required Date: 10/3/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CB200

Purchased

No

110

Each

11.0000

1

1

CB200

Acrylic Adhesive, 3.5G

DAS
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9-89

Location

Loc Qty

Loc Code

PKG

11

m136932

11

D4730-020-030

Manufactured

No

110

Each

7.0000

1

1

D4730-020-030

Velcro Strip 2.0W/ X 3.0L

Location

Loc Qty

Loc Code

ST112

7

163668

7

D4971-041

Manufactured

No

110

Each

1.0000

1

1

D4971-041

T/R Bellcrank Cover Assembly

Location

Loc Qty

Loc Code

ST621

1

162712

1

D5076-041

Manufactured

No

110

Each

1.0000

1

1

D5076-041

Fwd Bracket Assembly

Location

Loc Qty

Loc Code

ST617

1

163403

1

DAS
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SEP 22 2017
DAS
28
9-89

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SEP 22 2017
DAS
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9-89

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SEP 22 2017
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9-89

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SEP 22 2017
DAS
28
9-89

DAS
6
9-89

DAS
27
9-89

Picklist Print

Thursday, September 21, 2017 4:33:26 PM

Page 2

Work Order ID: 166432

166432

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 9/21/2017

Required Date: 10/3/2017

Start Qty: 1.00

Required Qty: 1.00

D3802-1 Manufactured No

110 f 25.5928 2 2

D3802-1

Window Seal (\$ per foot)

**

SEP 22 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST416

25.59275453

156349

0.00275453

164973

25.59

2

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4435-9 Manufactured No

110 Each 3.0000 2 2

D4435-9

Bracket

**

SEP 22 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST091

3

162714

3

D4436-041 Manufactured No

110 Each 4.0000 1 1

D4436-041

Aft Bracket Assembly

**

SEP 22 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST618

4

162719

4

D4441-1 Manufactured No

110 f 221.3312 2 2

D4441-1

Rubber Seal

**

SEP 22 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

ST422

221.3312

151347

221.3312

(D4441-1-240) CUT (1) AT 24.00" PER KIT

Picklist Print

Thursday, September 21, 2017 4:33:26 PM

Page 3

Work Order ID: 166432

166432

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 9/21/2017

Required Date: 10/3/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-3A Purchased No 110 Each 23.0000 5 5

AN3-3A

Bolt

DAS
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9-89

**

SEP 22 2017 DAS
6
9-89 DAS
28
9-89

Location Loc Qty Loc Code

ST350 23
m138409 23

AN525-10R6 Purchased No 110 Each 326.0000 2 2

AN525-10R6

Screw

DAS
27
9-89

**

SEP 22 2017 DAS
6
9-89 DAS
28
9-89

Location Loc Qty Loc Code

ST329 326
M137307 326

AN525-832R7 Purchased No 110 Each 33.0000 2 2

AN525-832R7

Screw

DAS
27
9-89

**

SEP 22 2017 DAS
6
9-89 DAS
28
9-89

Location Loc Qty Loc Code

ST328 33
m136983 33

MS21042L06 Purchased No 110 Each 162.0000 7 7

MS21042L06

Nut

DAS
27
9-89

**

SEP 22 2017 DAS
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9-89 DAS
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9-89

Location Loc Qty Loc Code

ST303 162
m137391 12
m137851 100
m138237 50

Picklist Print

Thursday, September 21, 2017 4:33:26 PM

Page 4

Work Order ID: 166432

166432

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 9/21/2017

Required Date: 10/3/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

110

Each

1,232.000

2

2

MS21042L08

Nut

SEP 22 2017

DAS 6 28 9-89 9-89

Location

Loc Qty

Loc Code

GA

286

m135978

49

m138333

237

ST303

946

m125445

1

m138044

24

m138333

921

DAS 27 9-89

MS21042L3

Purchased

No

110

Each

1,301.000

5

5

MS21042L3

Nut

SEP 22 2017

DAS 6 28 9-89 9-89

Location

Loc Qty

Loc Code

FP001

44

m135945

44

GA

302

m134360

102

M136665

200

ST303

955

m138230

453

m138326

2

m138408

500

DAS 27 9-89

5

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Thursday, September 21, 2017 4:33:26 PM

Page 5

Work Order ID: 166432

166432

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 9/21/2017

Required Date: 10/3/2017

Start Qty: 1.00

Required Qty: 1.00

MS21059L3 Purchased No

110 Each 85.0000 2 2

MS21059L3

Nut Plate

**

SEP 22 2017

DAS 6 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA
M137412
M137659
M137710
ST301
M138040

47
1
30
16
38
38

2

DAS 27 9-89

MS35206-229 Purchased No

110 Each 137.0000 7 7

MS35206-229

Screw

**

SEP 22 2017

DAS 6 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST271
M135603

137
137

4

DAS 27 9-89

NAS1149F0332P Purchased No

110 Each 1,060.000 10 10

NAS1149F0332P

Washer

**

SEP 22 2017

DAS 6 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA
m133709
ST262
m138209

77
77
983
983

10

DAS 27 9-89

NAS1149FN616P Purchased No

110 Each 72.0000 14 14

NAS1149FN616P

WASHER

**

SEP 22 2017

DAS 6 9-89

DAS 28 89

Location

Loc Qty

Loc Code

ST264
M137851

72
72

14

DAS 27 9-89

Thursday, September 21, 2017 4:33:27 PM

Shop Packet Print

Page 5

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Page 6

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Work Order ID: 166432

166432

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 9/21/2017

Required Date: 10/3/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN816P

Purchased

No

110

Each

346.0000

2

2

NAS1149FN816P

WASHER

SEP 22 2017

Location

Loc Qty

Loc Code

ST263

346

117316

346

DAS
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9-89

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Thursday, September 21, 2017 4:33:27 PM

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Page 6

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. E OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-18
FAA STC: SH989NE
FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350 B3e aircraft.

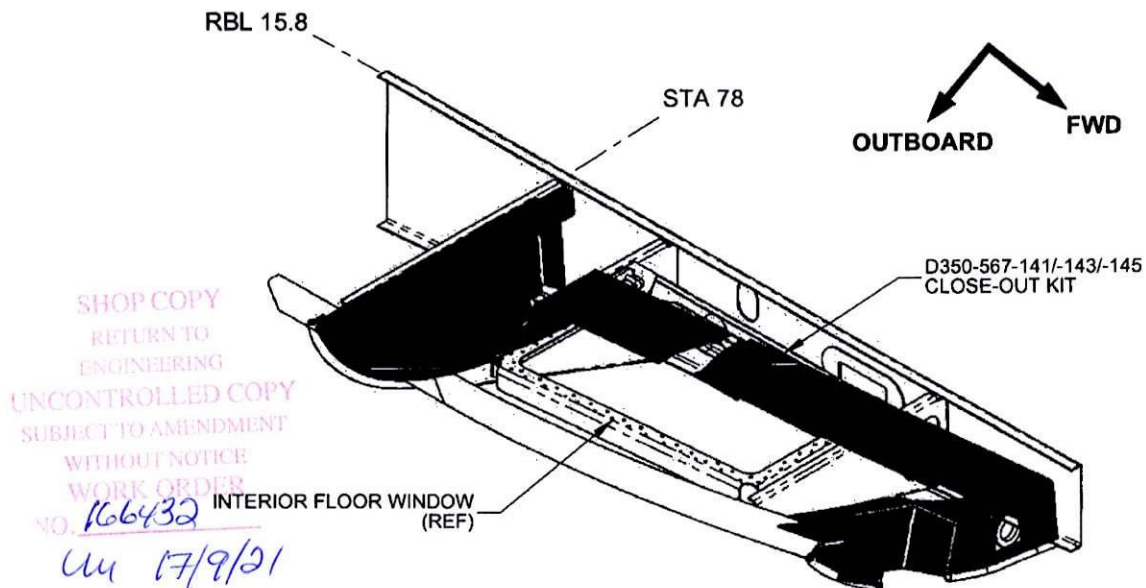


Figure 1. Floor Window Close-out Kit Installation

F	ADDED D4434-047 TO -141 KIT SEE PAR14-372.	AJS	15.01.12
E	ADD -143/-145 KITS	RF	14.03.20
E	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JS	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 19
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kG	65.5 in 1.66 m	255.5 in-lb 2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

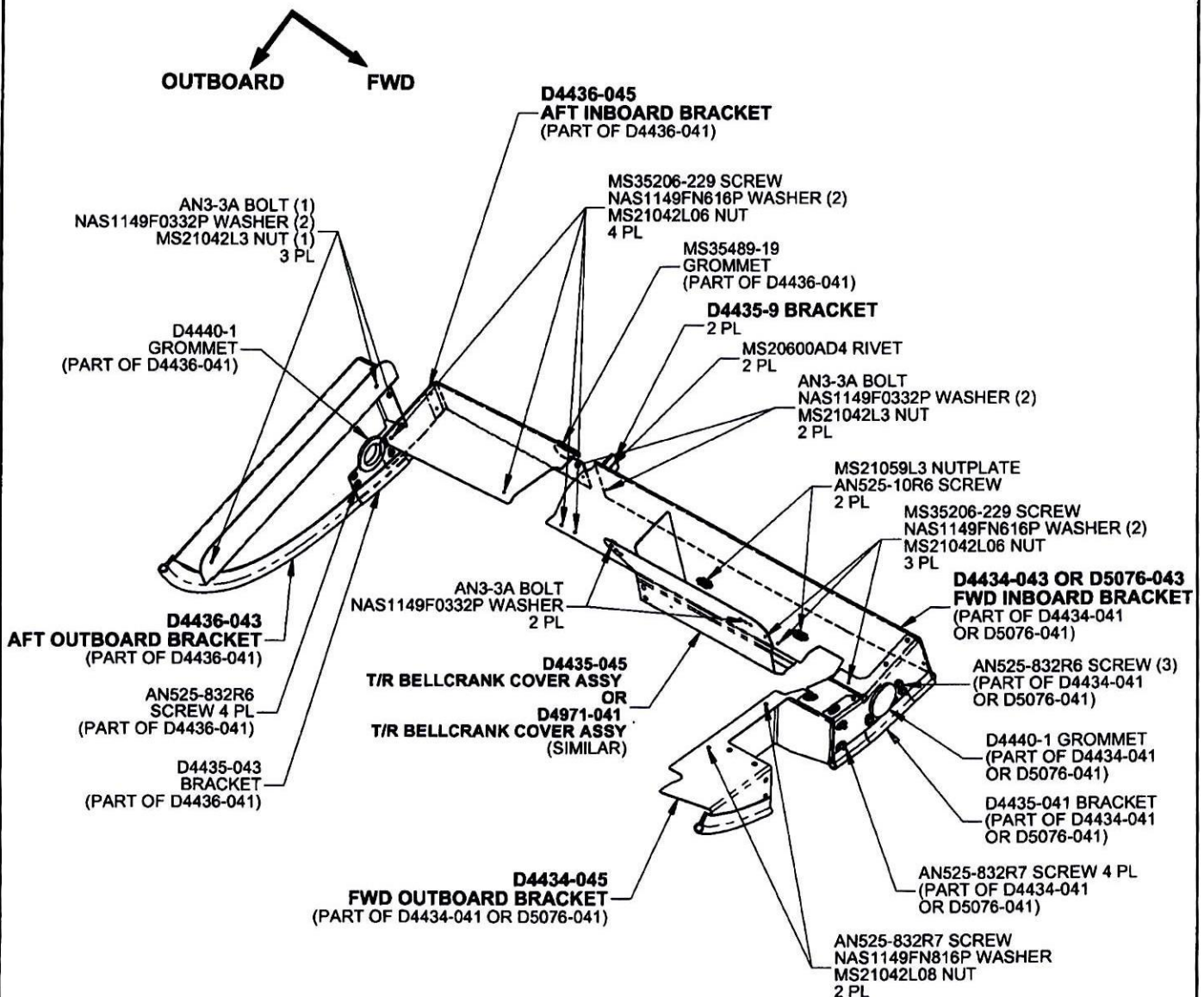


Figure 2. Floor Window Close-out Kit Installation

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DAO # 01-O-01

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D. SHEPHERD (DE # 02)

DATE: 15.01.12
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 3 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:

- a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
- b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

F 4.3 For -141 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.4 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.5 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.6 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.7 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.8 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.9 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.10 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.

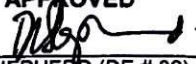
4.11 FOR D350-567-141 KIT

a) Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.

b) Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

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BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

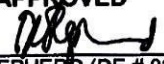
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 4 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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4.12 FOR D350-567-143/-145 KIT

- a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.
 - b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.
 - c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CB 200 adhesive.
 - d) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
 - e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.13 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.14 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.15 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.16 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141 /-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 5 OF 19
APPROVED		TITLE	SCALE
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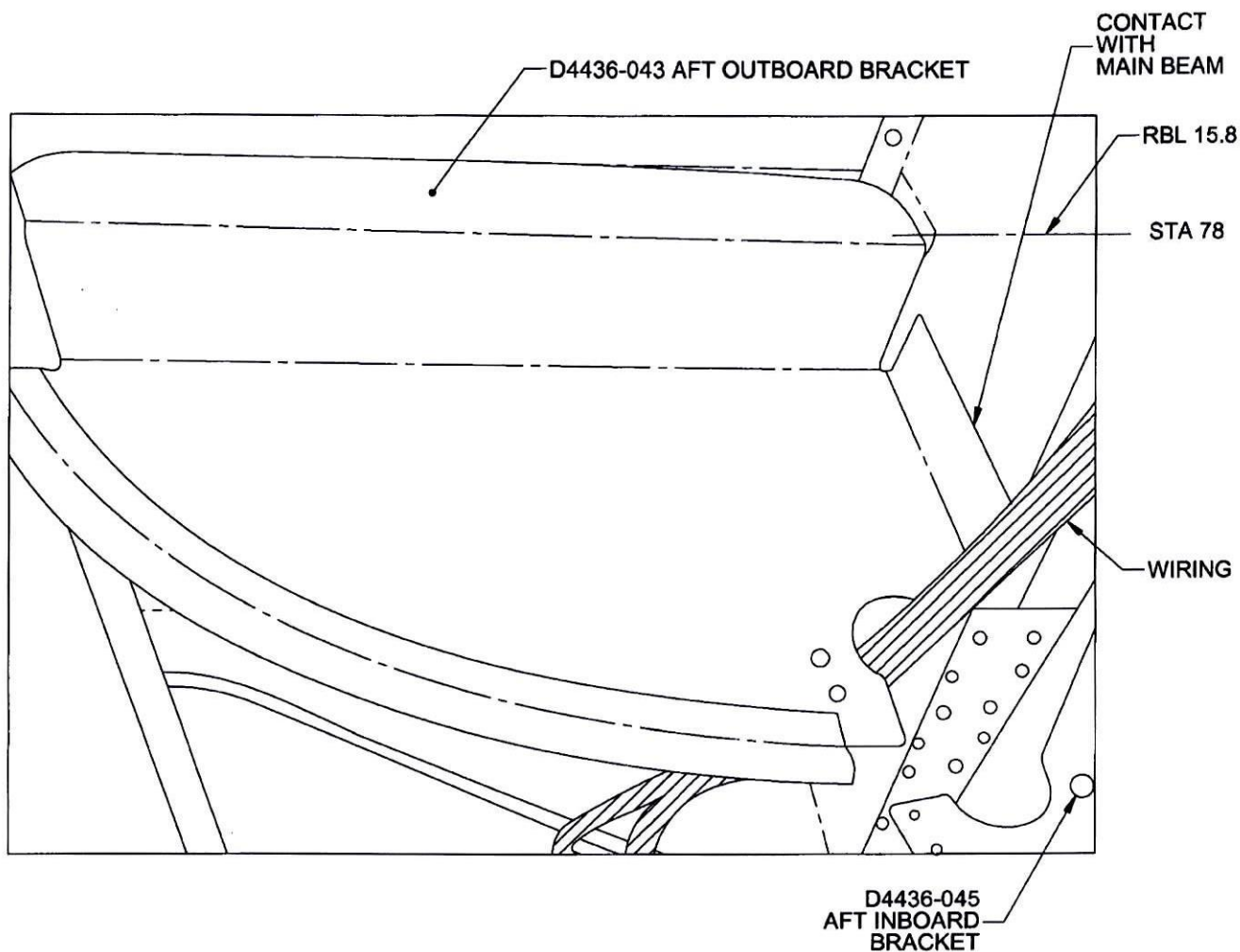


Figure 3. D4436-043 Aft Outboard Bracket Installation

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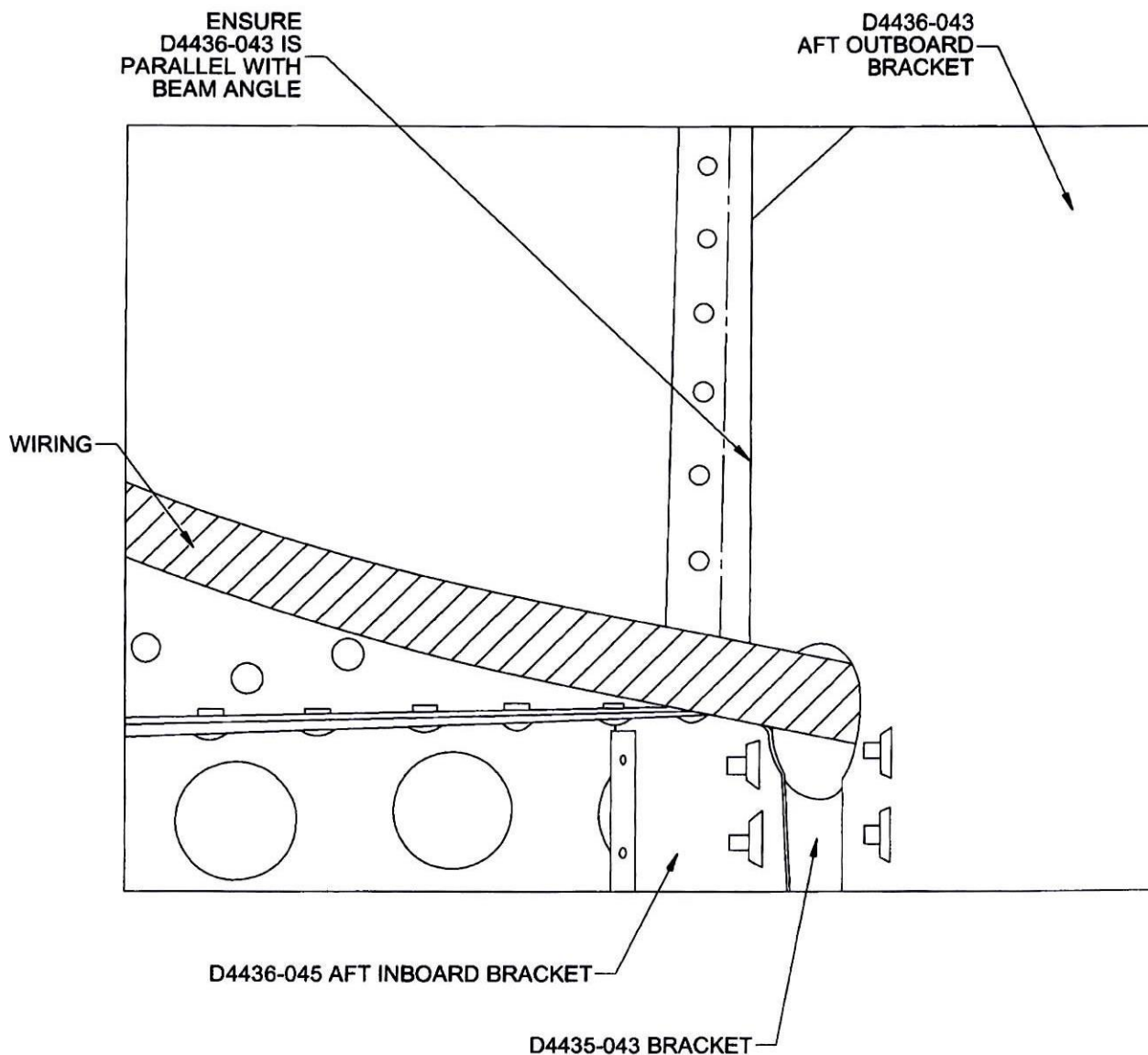


Figure 4. D4436-043 & D4435-043 Brackets Installation

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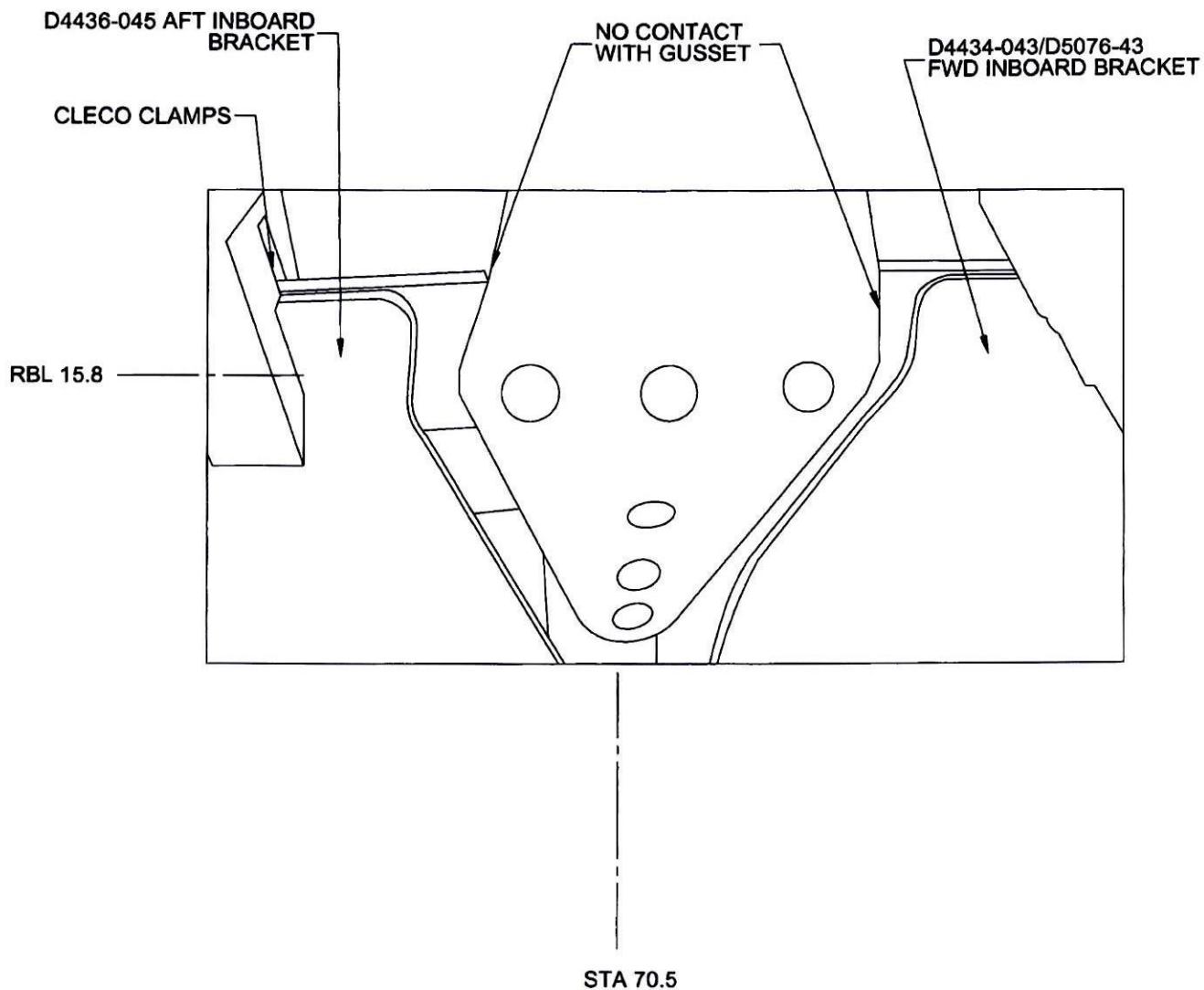


Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation

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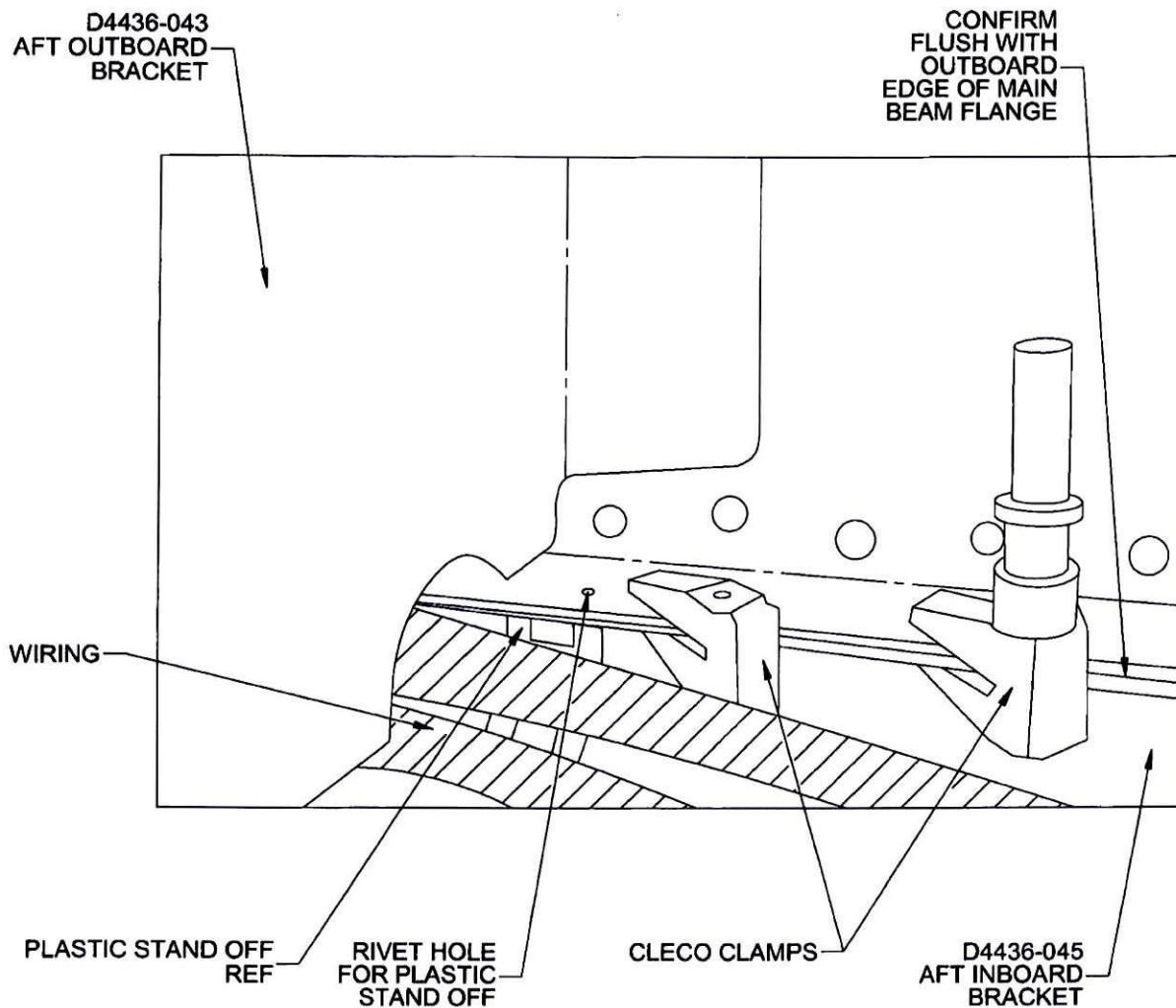


Figure 6. D4436-043 & D4436-045 Brackets Installation

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MFG. APPR.	N/A	DSI 9590	SHEET 9 OF 19
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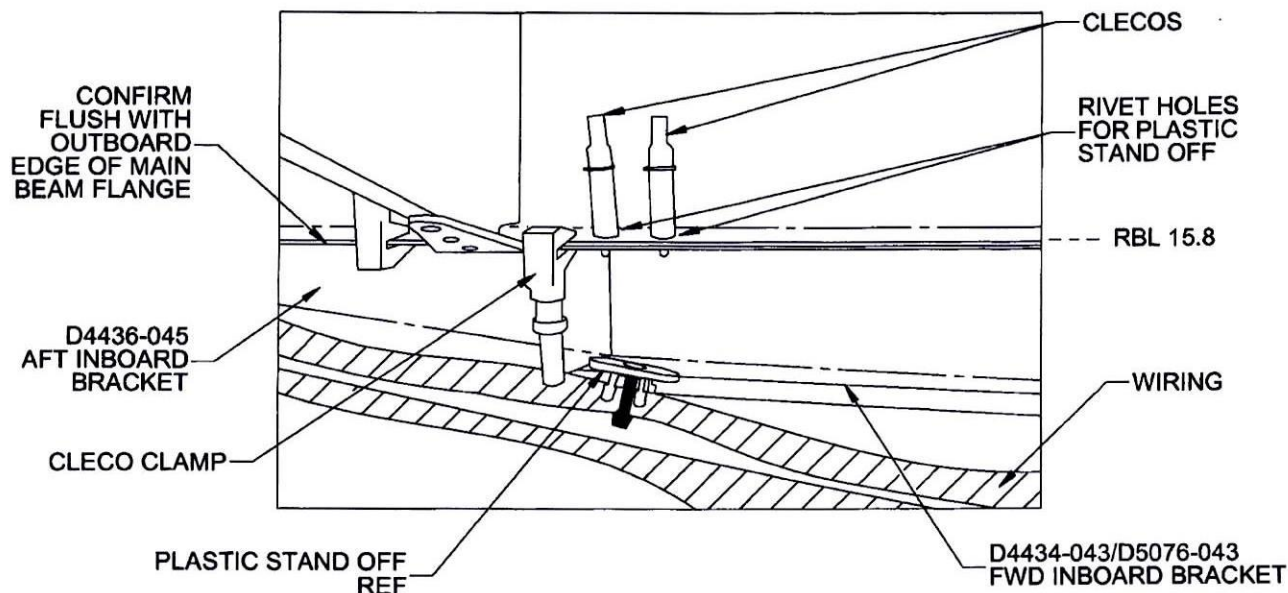


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

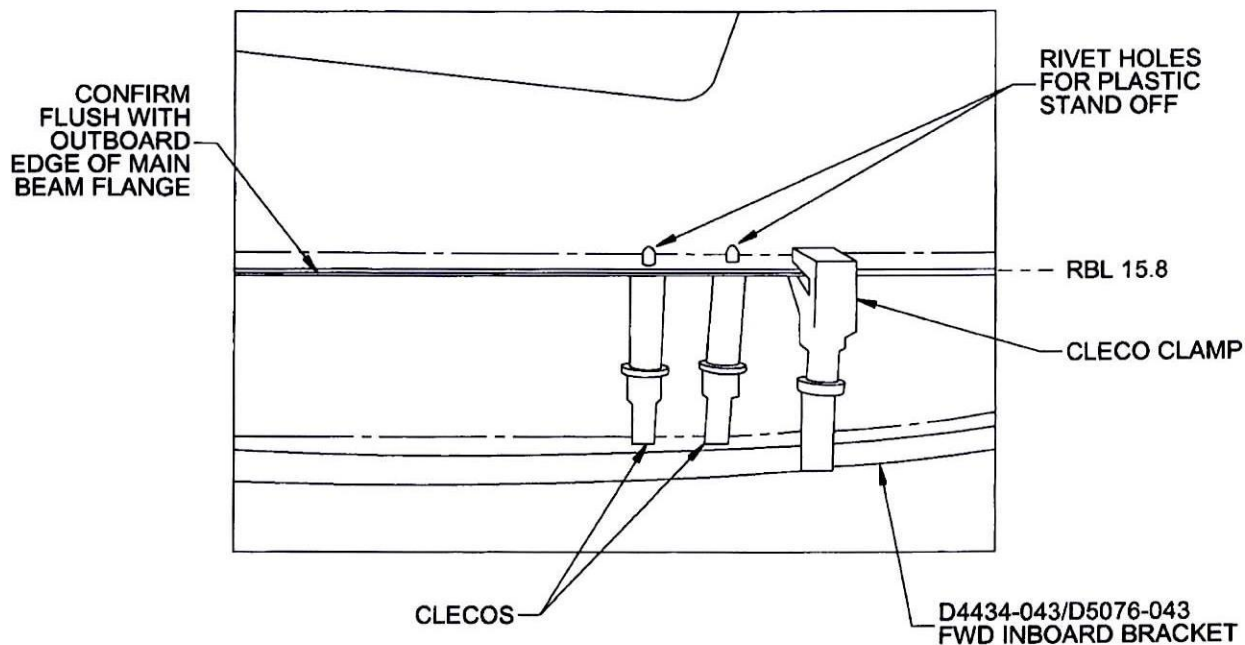


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation

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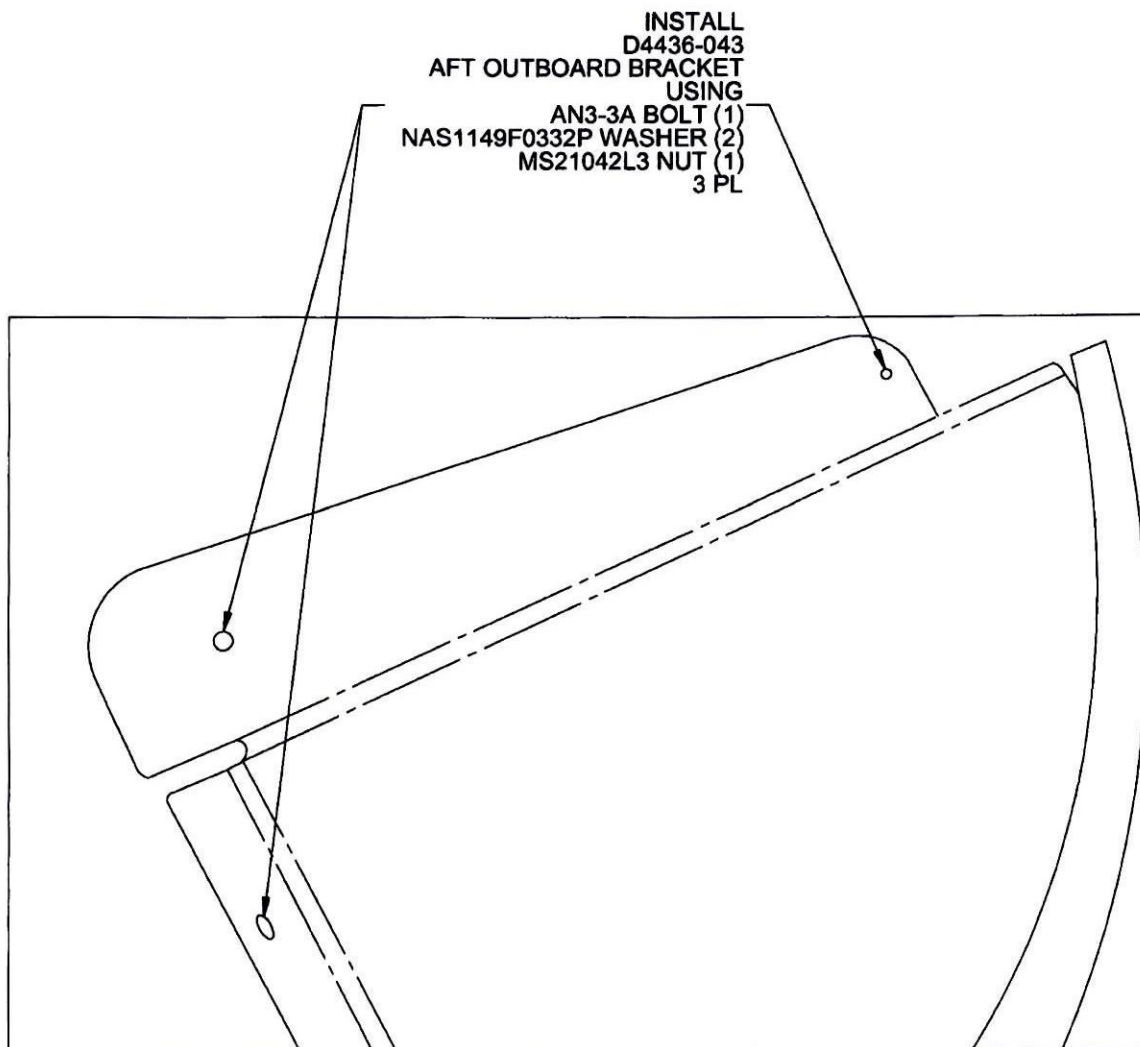


Figure 9. D4436-043 Aft Outboard Bracket Installation

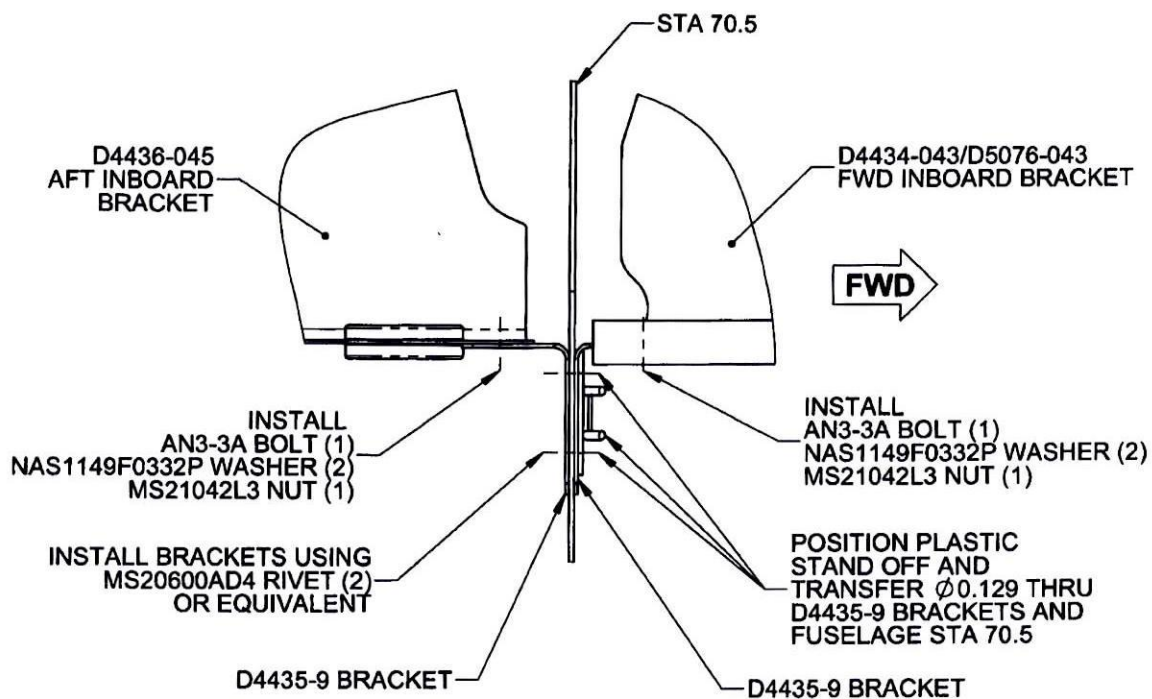
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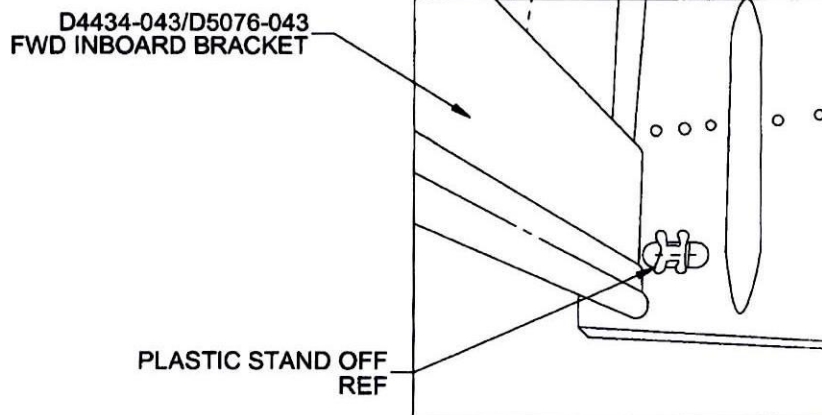


Figure 10. D4434-043/D5076-043 and D4435-9 Brackets Installation

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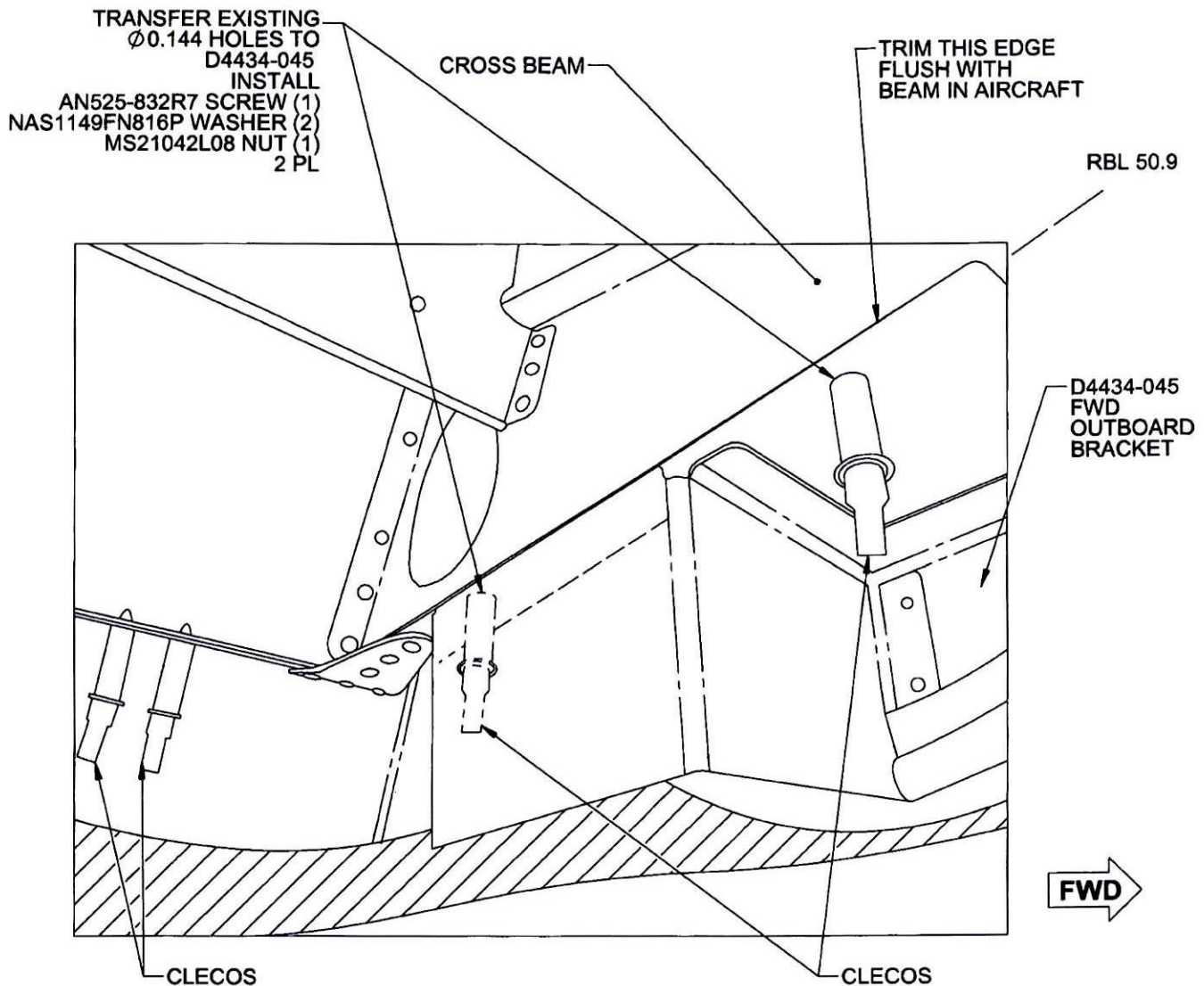


Figure 11. D4434-045 Bracket Installation

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MFG. APPR.	N/A	DSI 9590	SHEET 13 OF 19
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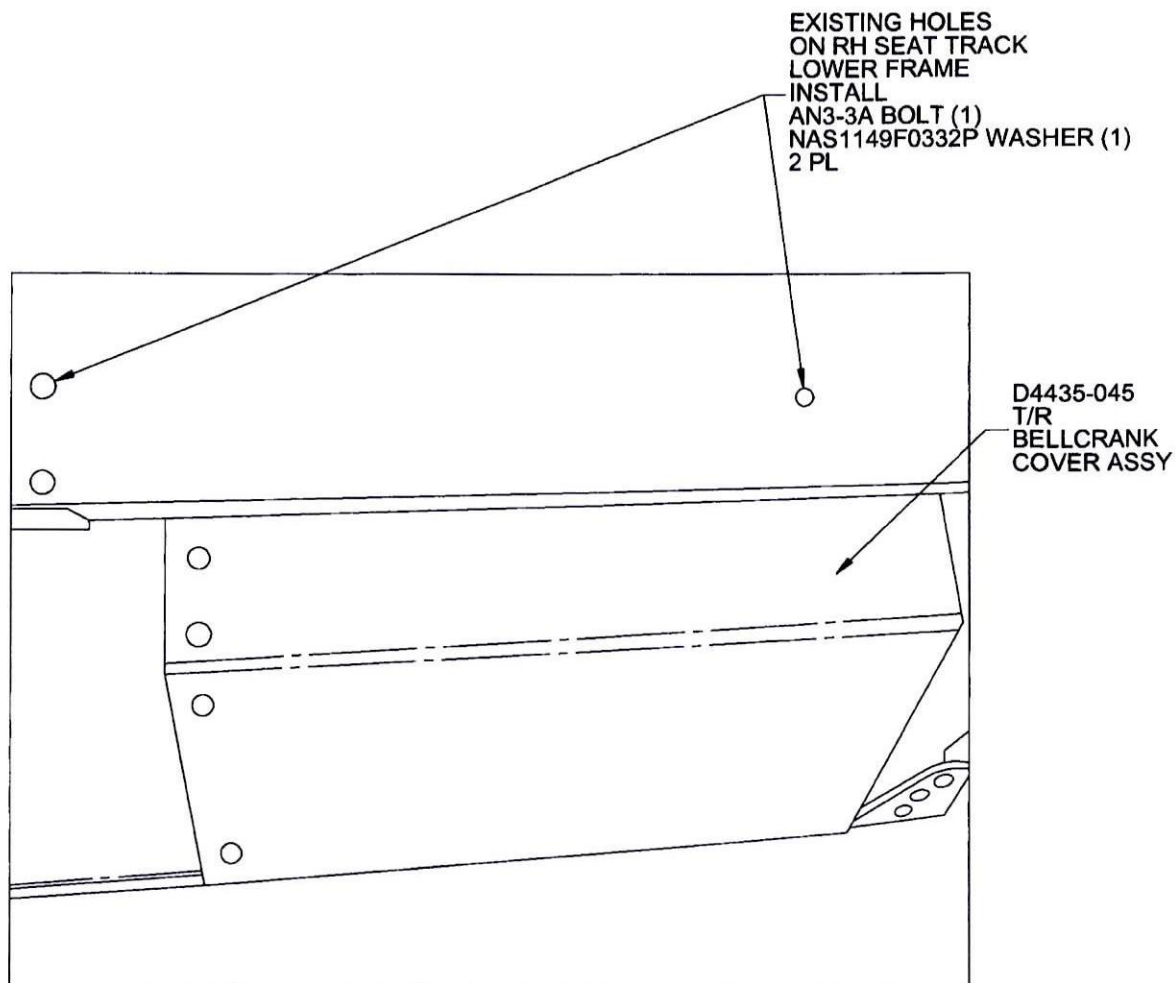
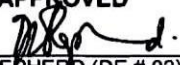


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

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CHECKED		DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A	SHEET 14 OF 19	
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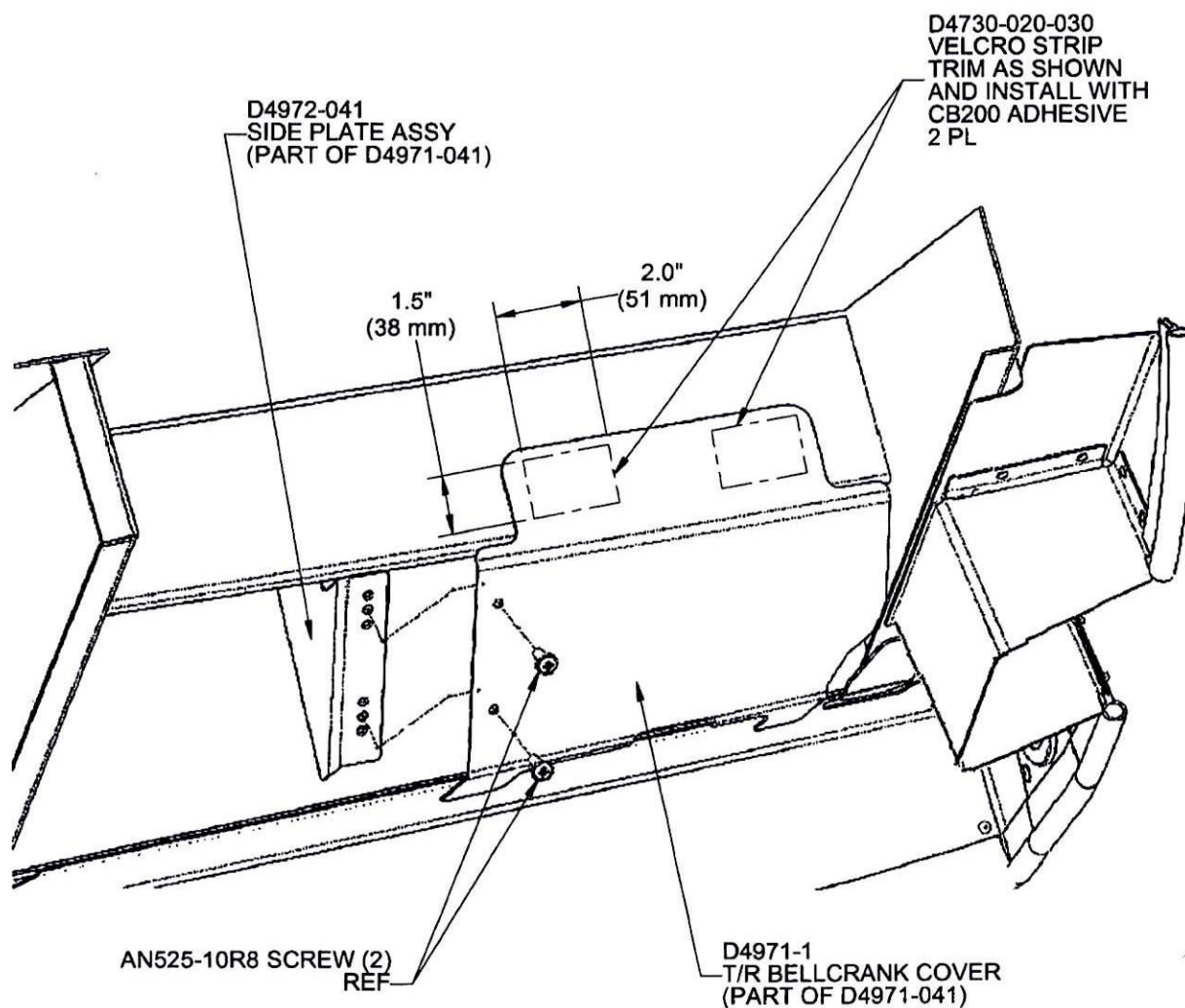


Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

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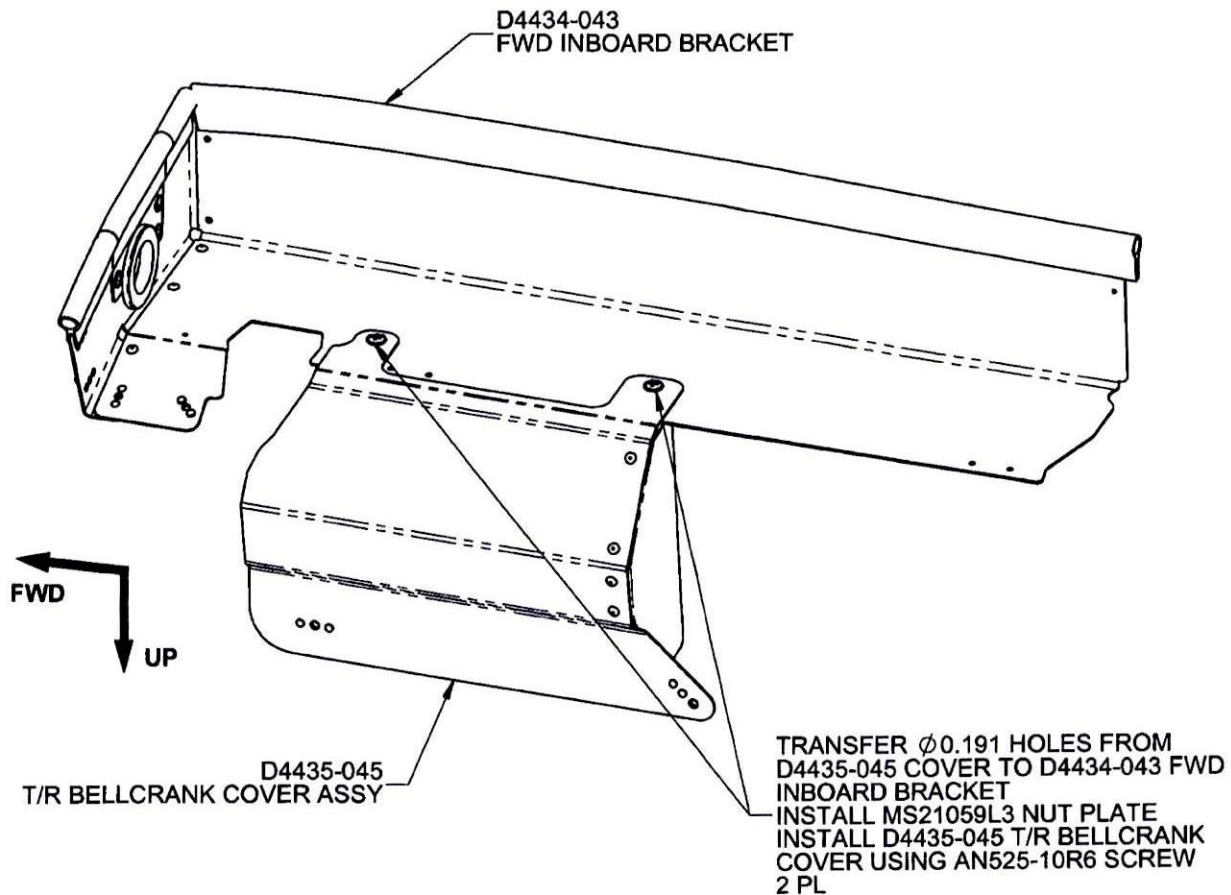


Figure 13a. D4435-045 Cover Installation (-141 ONLY)

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MFG. APPR.	N/A	DSI 9590	SHEET 16 OF 19
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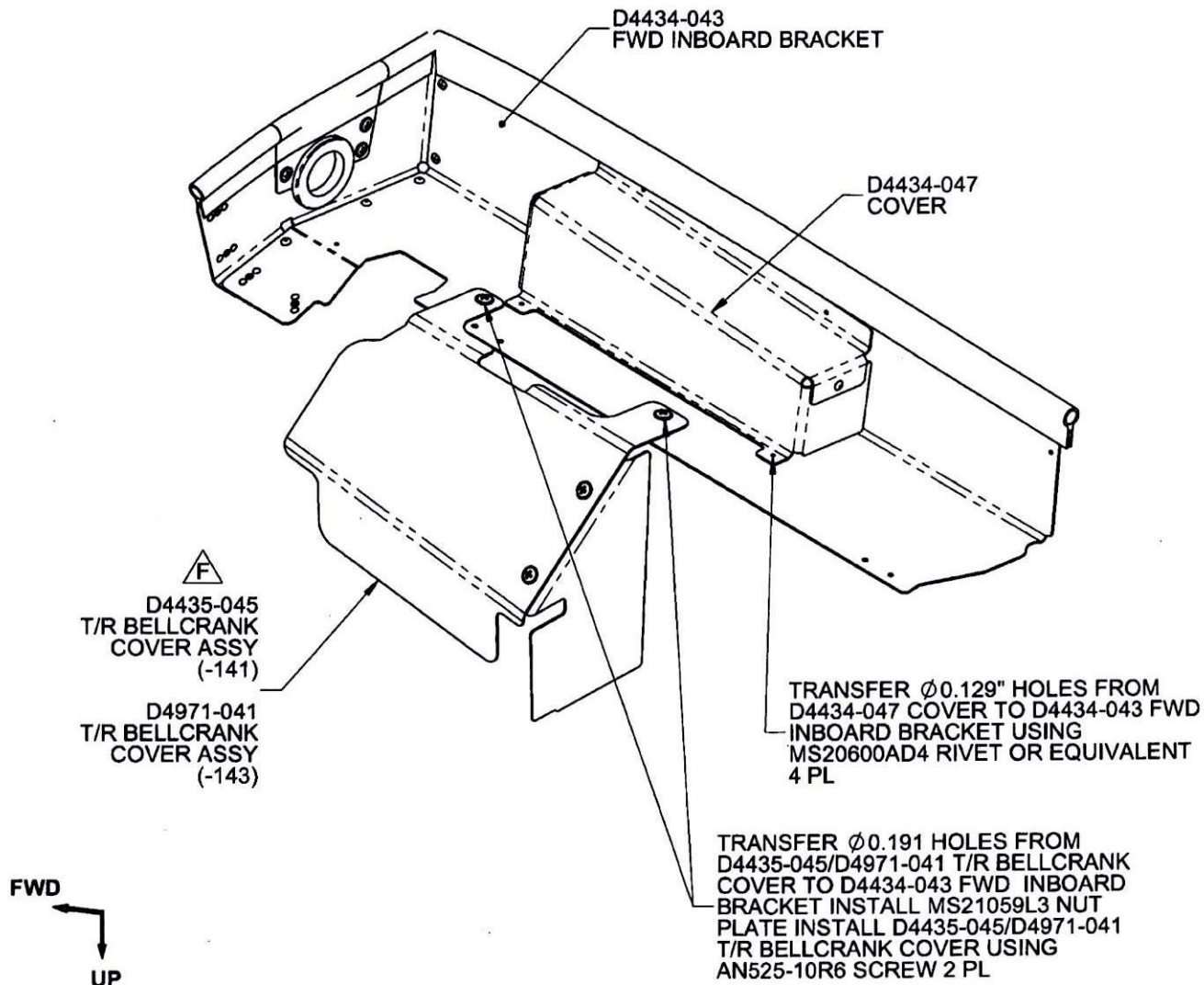


Figure 13b. D4971-041/D4435-045 & D4434-047 Cover Installation △
(D4434-047 is Optional on -141)

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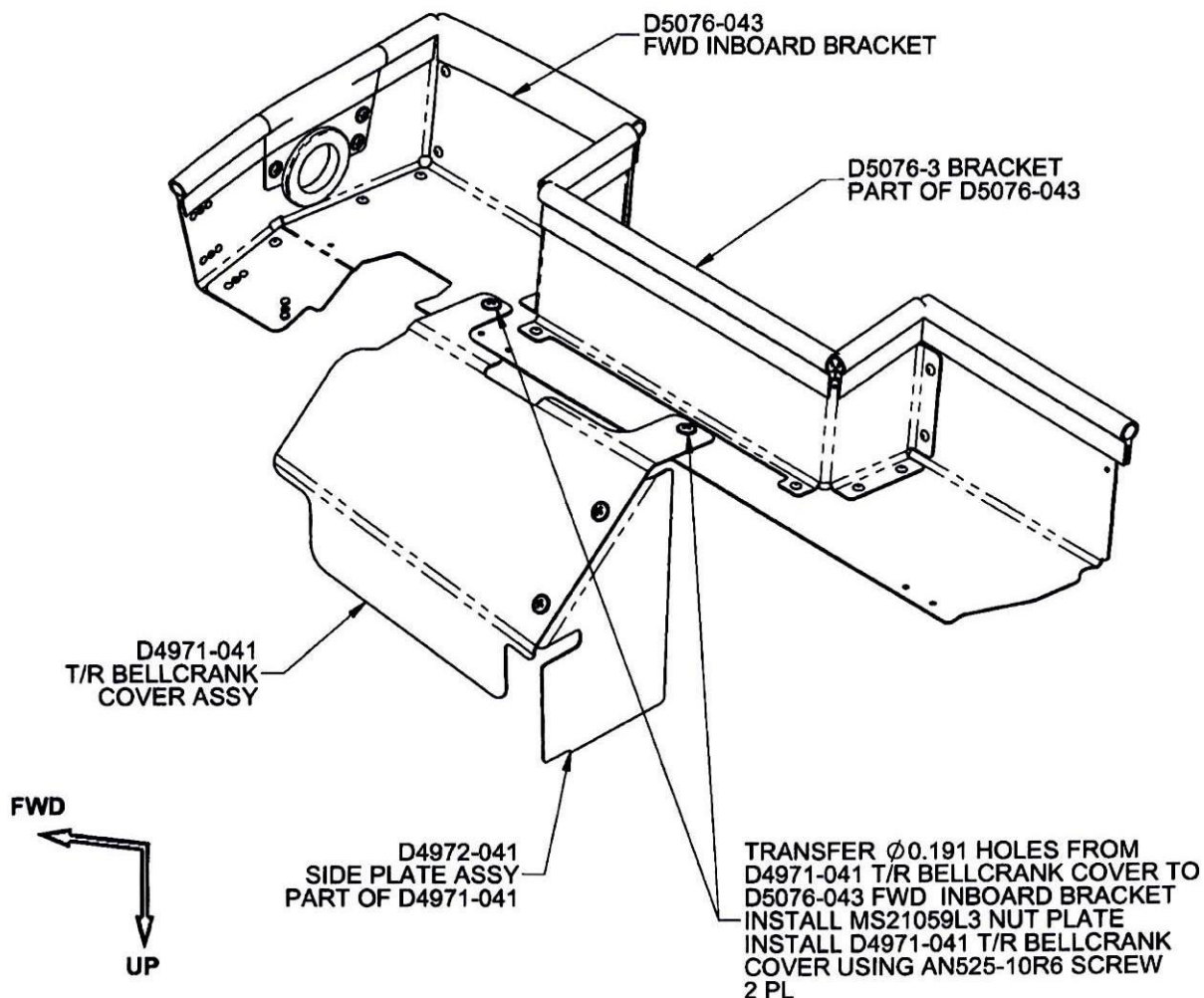


Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)

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MFG. APPR.	N/A	DSI 9590	SHEET 18 OF 19
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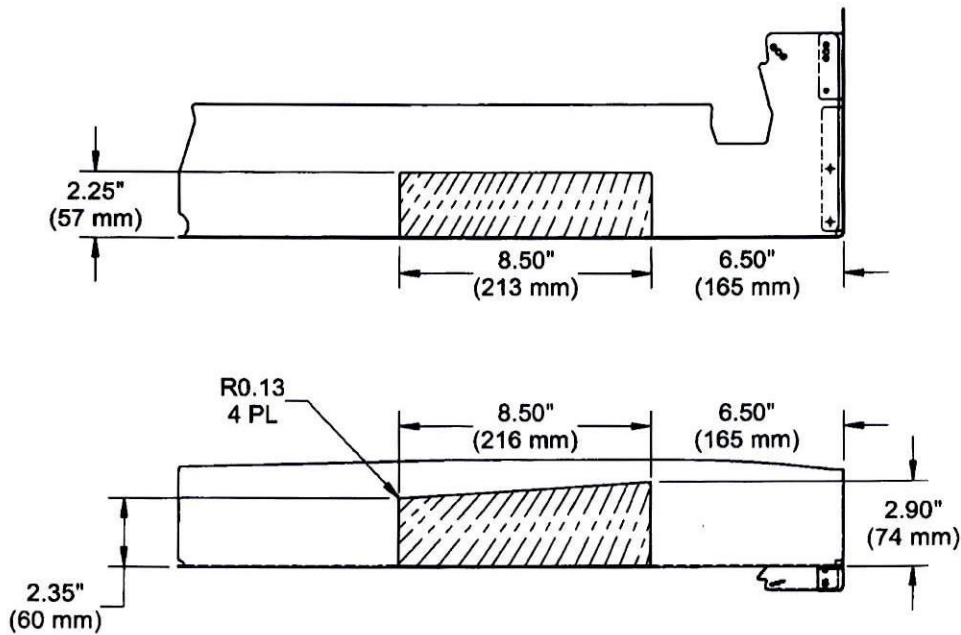
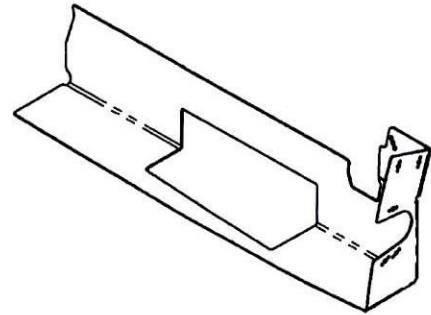


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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DAO # 01-O-01

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MFG. APPR.	N/A	DSI 9590	SHEET 19 OF 19
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166432

Thursday, September 21, 2017 4:33:27 PM

Work Order ID 166432

N900040100 Setup Start *NS1* Stop *NS2*

Item ID:	D350-567-145
Revision ID:	
Item Name:	Floor Window Close Out (AS350 B3e)
Start Date:	9/21/2017
Required Date:	10/3/2017
Start Qty:	1.00
Req'd Qty:	1.00
Reference:	012-2716-5

Approvals:	Process Plan:	Date:	Tooling:	Date:	SPC (Y/N):	Date:
QC:						
Run	Start	Stop	*NR1*	*NR2*		

Sequence ID/ Work Center ID	Draw Nbr	Revision Nbr	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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SEP 22 2017 0.00

100
Document Control
100-
DOCUMENT CONTROL

Doc: Control - L/SB or Paperwork	Memo	0.00
	Photocopy bluefile & type labels per PPP D350-567-145 (11/30/01)	

110
110
Packaging
Packaging

	Pick Kit	Memo
	0.00	0.00

UCL

QC +/- 100% inspect kits for completeness	Memo
0.00	0.03



Transport
Canada

Transports
Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH92-18

Issue No.: 6

Approval Date: April 21, 1992

Issue Date: February 04, 2009

Responsible Office:

Ontario

Aircraft/Engine Type or Model:

EUROCOPTER FRANCE AS 350 BA, AS 350B, AS 350B1, AS 350B2, AS 350B3, AS 350D, AS 350D1, AS 355 E, AS 355 F, AS 355 F1, AS 355 F2, AS 355 N, AS 355 NP

Canadian Type Certificate or Equivalent:

EUROCOPTER FRANCE AS 350 BA, AS 350B, AS 350B1, AS 350B2, AS 350B3, AS 350B3, AS 350D, AS 350D1, H-83
EUROCOPTER FRANCE AS 355 E, AS 355 F, AS 355 F1, AS 355 F2, AS 355 N, AS 355 NP H-87

Description of Type Design Change:

Installation of vertical reference (floor) window.

Installation/Operating Data:

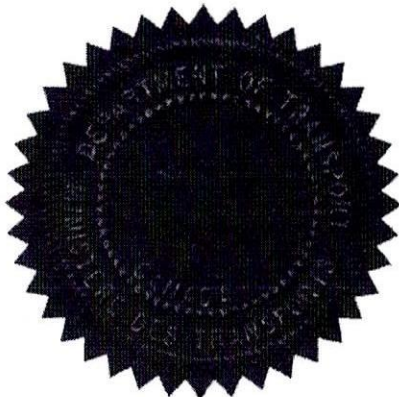
Required Equipment and Limitations:

Manufacturing must be accordance with Dart Aerospace Ltd. Master Drawing List MDL-D350-567, Revision A dated January 23, 2009 or later TC approved revision.

Installation must be in accordance with Dart Aerospace Installation Instructions D350-567, Revision D, dated July 8, 2008 or later TC approved revision.

Maintenance must be in accordance with Dart Aerospace Instructions for Continued Airworthiness, ICA-D350-567, Rev 0 dated January 20, 2009 or later TC accepted revision is required.

- END -



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.


M. Mariotti
For Minister of Transport

Canada

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)



3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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